

Date: Thursday, 11/09/2008 10:41:51 AM  
User: Julie Lecocq

# Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	PLUG
<b>Job Number</b> :	41971		
<b>Estimate Number</b> :	10512		
<b>P.O. Number</b> :		<b>Part Number</b> :	D26511
<b>This Issue</b> :	11/09/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D2651 REV. B
<b>First Issue</b> :	/ /	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	41636	<b>Drawing Revision</b> :	B
	<b>Type</b> :	<b>Material</b> :	
	MACHINED PARTS	<b>Due Date</b> :	30/09/2008
<b>Written By</b> :		<b>Qty:</b>	100
<b>Checked &amp; Approved By</b> :	JUD 08.9.11	<b>Um:</b>	Each
<b>Comment</b> :	Est: A 02.04.15 New Issue NG Est: B 05.12.12 added deburr EC		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M6061T6R0500	6061-T6 Round Bar .500"
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**Comment:** Qty.: 0.0421 f(s)/Unit Total : 4.2105 f(s)  
 Material: 6061-T6 (QQ-A-225/8) 0.500" Dia  
 (M6061T6R0500)  
 Batch: M107676

MNF 08/09/19

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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**Comment:** HAAS CNC VERTICAL MACHINING #1  
 1- Turn as per Folio FA219 and Dwg D2651  
 2- Deburr

MNF 08/09/19

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

MNF 08/09/19

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

88 08/09/20 (100)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1  
 Deburr ias per dwg D2651

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 11/09/2008 10:41:51 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 41971

Part Number: D26511

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



100X

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-L 08/04/22

7.0

POWDER COATING

POWDER COATING



100X

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

(Only larger section necessary)

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:00  
325 OF  
1:30

M-L 08/04/24

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08-09-24

X100

9.0

PACKAGING 1

PACKAGING RESOURCE #1



100X

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

F-P-A

M-L 08/04/24

10.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/26

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



M-L 08-09-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



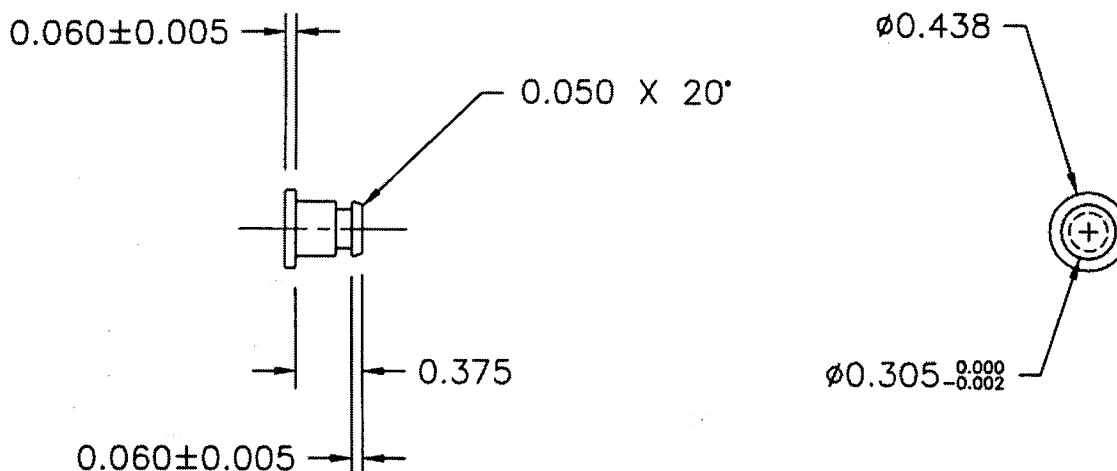


DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2651	REV. B SHEET 1 OF 1
DATE 03.12.19		TITLE PLUG	SCALE 1:1
A	97.03.25	NEW ISSUE	
B	03.12.19	ADD POWDER COAT, MS28775-008	

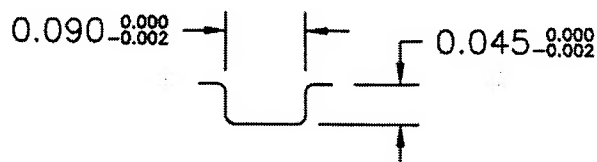
RELEASED

03.12.19

### D2651-1 PLUG:



### GROOVE DETAIL (SCALE 5:1)



### D2651-1 PLUG

- 1) MATERIAL: 6061-T6 (QQ-A-225/8) OR 1100-0 (QQ-A-225/1)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 MAX

### D2651-3 O-RING

- 1) MATERIAL: BUNA N, 70 DUROMETER  
3/16 ID, 5/16 OD, 1/16 WIDTH  
(PARKER 2-008, MS28775-008 OR EQUIVALENT)

NOTED  
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WORK ORDER  
NO. 44977

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